



SECTION A-A

1. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.

- ALCATEL SAM-110TCL
Du PONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR
SENSITIVITY SHALL BE PERFORMED JUST
PRIOR TO TESTING.

CHAMBER WILL BE REJECTED IF A 2% DEFLECTION
ON THE MOST SENSITIVE RANGE OF THE LEAK
DETECTOR IS SENSED WITHIN 1 MIN.

3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

4. DIMENSIONS IN [] ARE MILLIMETERS

4. DIMENSIONS IN [] ARE MILLIMETERS
5. SHIELDED CAN SHALL BE TO SLIDE FREELY
6. THIS UHV PART MUST BE BAKEABLE TO 170 C

A2267600	6	P4105090602-312023-00	U2 TRANSITION PIPE 1-D-ID, END PLATE	304 SS	1
A2443300	5	P4105090602-311201-00	U2 TRANSITION PIPE 3-D-ID, LEAD COIL	LEAD GRADE "C"	1
	3		TUBING : 5.25[133.35] O.D. x .065[3.17] WALL	304 SS	1
	4		TUBING : 4.00[100.00] O.D. x .125[3.17] WALL	304 SS	1
	2		FLANGE NONROTATABLE: 8" O.D. MDC#110031	304 SS	1
	1		FLANGE ROTATABLE: 6" O.D.X4".1. MDC#100026	304 SS	1

[illegible]

ARGONNE NATIONAL LABORATORY

ADVANCED PHOTON SOURCE
U2 TRANSITION PIPE
FOR 3-ID-C EXIT

SCALE 1:1	SUR	PROJNO 40000
SHEET 1 of 1	D	P4105090602-311200-00